









Work Order ID 68722

Wednesday, April 20, 2011 10:21:49 AM




Page 1


Item ID: D4271-011 Accept  Setup Start 
Revision ID:
Item Name: Fwd Beam Assembly Stop 
Start Date: 4/20/2011 Start Qty: 2.00  Cust Item ID:
Required Date: 4/25/2011 Req'd Qty: 2.00  Customer:
Reference:
Approvals: Process Plan:  Date: 4/20/2011 Tooling: _____ Date: _____ Run Start 
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr								
D4271	B								

100		0.00							
									
Small Fab	Memo	0.00							
Small Fab	1- Pick and Assemble as per dwg								

EP 11/4/20 (2)

110	QC5- Inspect part completeness to step on W/O	0.00							
									
QC	Memo	0.00							
Quality Control									

(72)

120	Identify as per dwg & Stock Location: <u>196</u>	0.00							
									
Packaging	Memo	0.00							
Packaging									

11/4/20 (2) EP

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 68722

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Item ID: D4271-011

Accept



Setup Start



Revision ID:

Stop



Item Name: Fwd Beam Assembly

Start Date: 4/20/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 4/25/2011 Req'd Qty: 2.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/4/25 [Signature]
ME
11-04-25

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Picklist Print

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Page 1

Work Order ID: 68722

Parent Item: D4271-011

Parent Item Name: Fwd Beam Assembly

Start Date: 4/20/2011





Required Date: 4/25/2011

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP rev:A 10.11.18 new issue DD verf:EC
11.01.26 RevB dwg EC verified by:DD

IPP RevA

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4149-5  Eyebolt Stud		Manufactured	No			100	Each	2.0000	1	2		4/11/04/20	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST133				2					
					66897			2					
D4274-1  Plate, Fwd Support		Manufactured	No			100	Each	6.0000	2	4		4/11/04/20	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST139B				6					
					68163			6					
D4275-1  Fwd Beam		Manufactured	No			100	Each	3.0000	1	2		4/11/04/20	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				st200				3					
					65884			3					
D4281-1  Spacer		Manufactured	No			100	Each	4.0000	1	2		4/11/04/20	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST139				4					
					66705			4					

W/O:		WORK ORDER CHANGES					
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Page 2

Work Order ID: 68722

Parent Item: D4271-011


Parent Item Name: Fwd Beam Assembly

Start Date: 4/20/2011


Required Date: 4/25/2011

Start Qty: 2.00


Required Qty: 2.00

AN3C12A Purchased No 100 Each 51.0000 6 12

 Bolts


Location	Loc Qty	Loc Code
ST351	51	
116924	6	
117313	45	

AN4C13A Purchased No 100 Each 35.0000 2 4

 BOLT

Location	Loc Qty	Loc Code
ST353	35	
117366	35	

MS20615-4M18 Purchased No 100 Each 346.0000 8 16

 Rivet

Location	Loc Qty	Loc Code
ST323	346	
117411	346	

MS21043-3 Purchased No 100 Each 948.0000 6 12

 Nut

Location	Loc Qty	Loc Code
FG	80	
103691	80	
FP-B	-5	
112314	-5	
ST301	873	
112314	873	

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Shop Packet Print

Page 2

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Picklist Print

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Work Order ID: 68722

Parent Item: D4271-011

Parent Item Name: Fwd Beam Assembly

Start Date: 4/20/2011

Required Date: 4/25/2011

Start Qty: 2.00

Required Qty: 2.00

MS21043-4

Purchased

No

100

Each

1,180.000

2

4



Nut



Ep 11/04/20

Location

Loc Qty

Loc Code

FG	40	
104603	40	
ST300	600	
117423	600	
ST301	540	
114523	3	
116188	237	
116549	300	

4.

NAS1149C0332R

Purchased

No

100

Each

5,261.000

12

24



Washer



Ep 11/04/20

Location

Loc Qty

Loc Code

ST297	5261	
116304	55	
117291	4606	
117460	600	

24

NAS1149C0432R

Purchased

No

100

Each

6,492.000

4

8



Washer



Ep 11/04/20

Location

Loc Qty

Loc Code

ST297	6492	
116900	1492	
117291	5000	

0

W/O:		WORK ORDER CHANGES					
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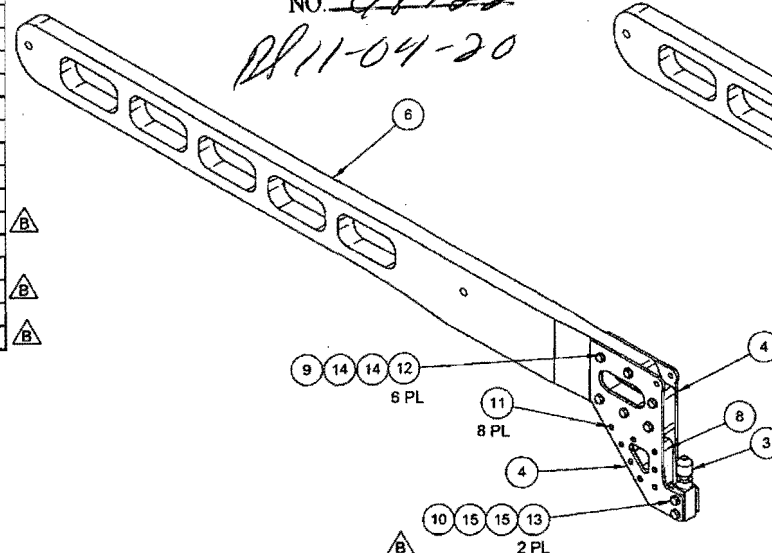
NOTE: Date & initial all entries

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY

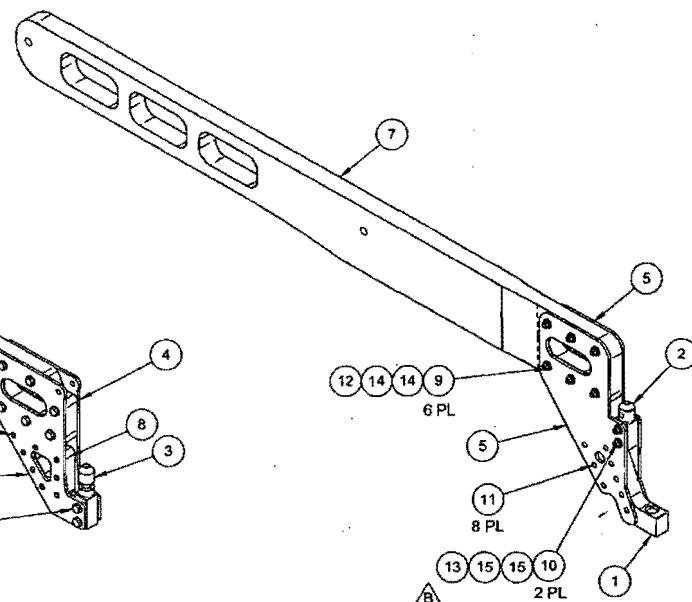
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *48722*

11-04-20

ITEM	QTY -011	QTY -013	PART NUMBER	DESCRIPTION
			D4271-011	FWD BEAM ASSY
			D4271-013	AFT BEAM ASSY
1		1	D4148-3	STUD RECEIVER
2		1	D4148-5	EYEBOLT STUD
3	1		D4149-5	EYEBOLT STUD
4	2		D4274-1	PLATE, FWD SUPPORT
5		2	D4274-3	PLATE, AFT SUPPORT
6	1		D4275-1	FWD BEAM
7		1	D4276-1	AFT BEAM
8	1		D4281-1	SPACER
9	6	6	AN3C12A	BOLT
10	2	2	AN4C13A	BOLT
11	8	8	MS20615-4M18	RIVET
12	6	6	MS21043-3	NUT
13	2	2	MS21043-4	NUT
14	12	12	NAS1149C0332R	WASHER
15	4	4	NAS1149C0432R	WASHER



D4271-011 FWD BEAM ASSEMBLY



D4271-013 AFT BEAM ASSEMBLY

RELEASED
2010-12-06

B	ITEM 10 CHANGED FROM AN3C12A TO AN4C13A	SC	10.12.01
A	NEW ISSUE	SC	10.11.25
REV.	DESCRIPTION	BY	DATE
DESIGN	JPH		
DRAWN	SC		
CHECKED	<i>[Signature]</i>		
MFG. APPR.	<i>[Signature]</i>		
APPROVED	<i>[Signature]</i>		
DE APPR.	<i>[Signature]</i>		
DATE	10.12.01		
DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D4271 TITLE SUPPORT BEAM ASSEMBLIES SCALE NTS SHEET 1 OF 2 REV. B COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY MANNER WITHOUT THE WRITTEN PERMISSION FROM DART AEROSPACE LTD			

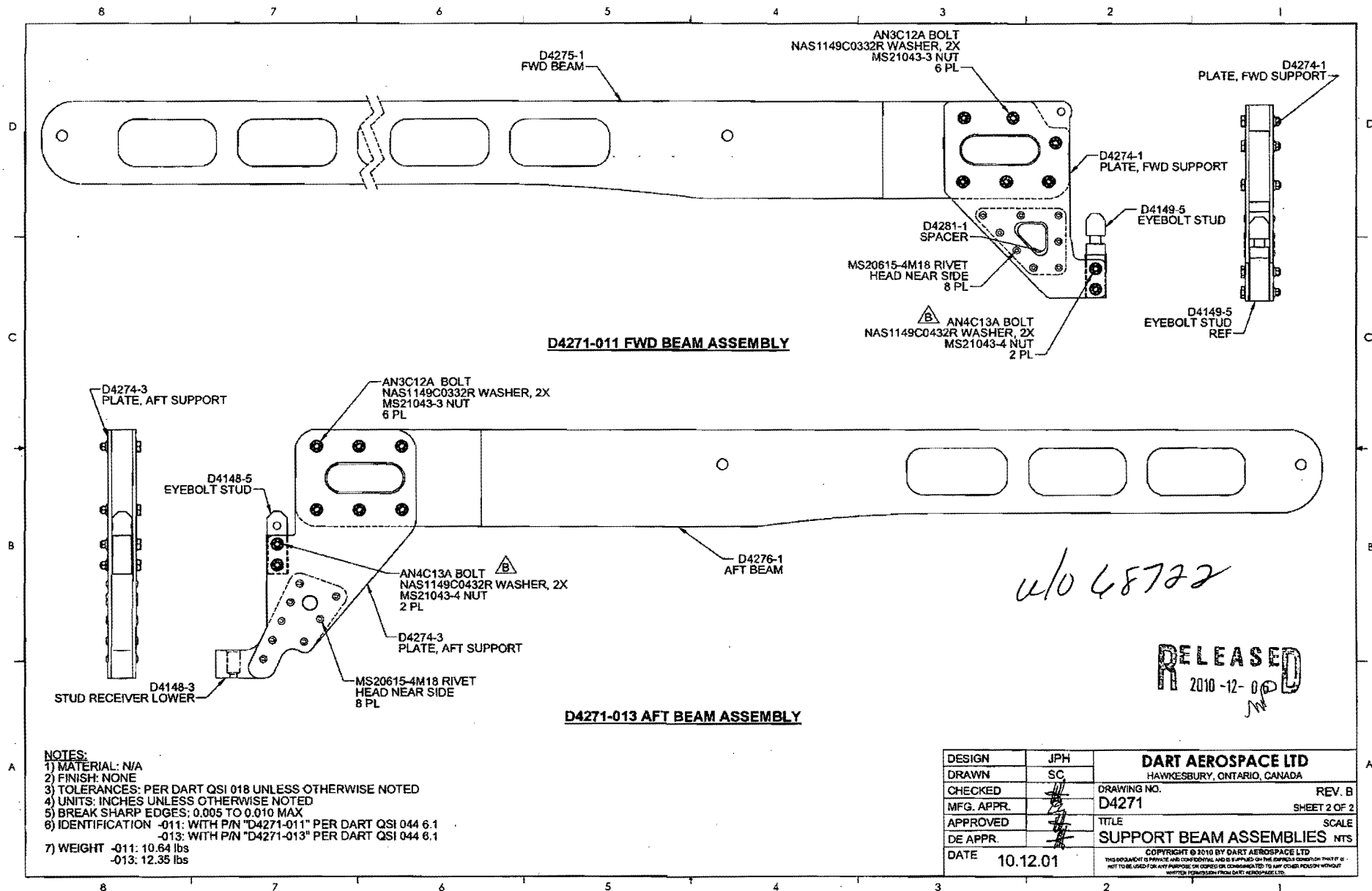
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